

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001870**Date Inspected:** 17-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG		

Summary of Items Observed:

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following.

Bay 7- QA Inspector performed ultrasonic verification testing of 10% of the Floor Beam Sub Assembly Complete Joint Penetration (CJP) at welds joints FB016-04-045 and FB008-06-045. The Ultrasonic Testing (UT) was performed to verify that 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A and from face B. QA Inspector utilized scanning patterns A, B, C, and E. For details please see the ultrasonic testing report TL-6027 dated March 17, 2008. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

Bay 1- QA Inspector performed an Ultrasonic Test (UT) verification of U-Rib Complete Joint Penetration (CJP) on the following U-Rib splice welds for a length of 300mm on each leg of the rib: DP002-001-010 thru DP002-001-013 and DP008-001-008. The Ultrasonic Testing (UT) was performed to verify that 10% of the welds meet the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60. QA Inspector performed a base metal lamination check using a 25mm

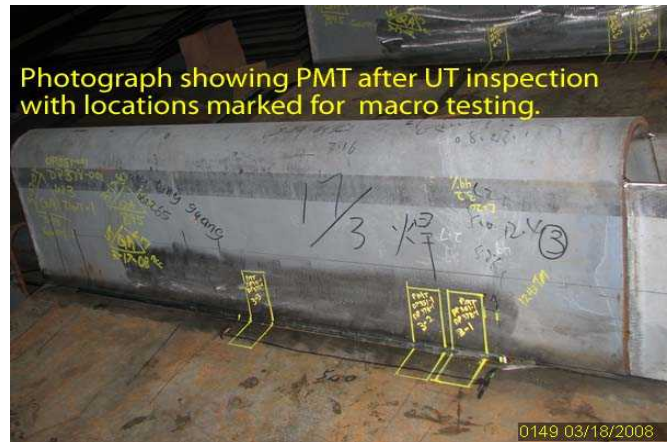
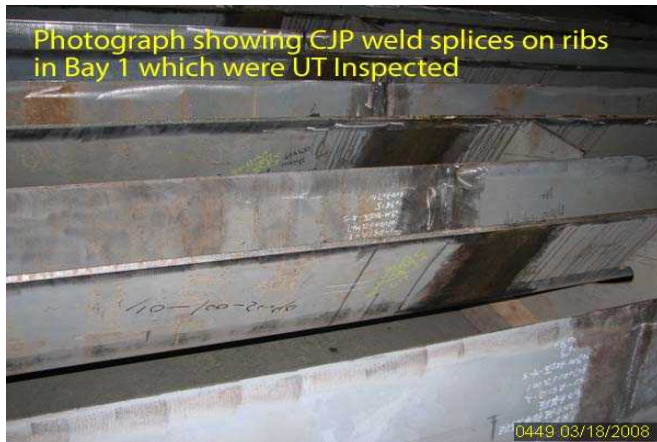
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diameter 2.25 MHz transducer and a shear wave scans using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. QA Inspector utilized scanning patterns A, B, C, D and E. For details please see the ultrasonic testing report TL-6027 dated March 17, 2008. QA Inspector found the welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

Bay 1- QA Inspector performed Ultrasonic Test (UT) inspection on three Production Monitoring Tests (PMT's) ribs for Deck Panels DP351-001 and DP378-001. Welding of the PMT's was completed and on 03-17-2008. PMT welds are identified as PMT#1 Weld #1 thru #6. Each of the six welds PJP welds inspected appear to be in compliance with the contract documents, approved plans, fabrications documents and Special Provisions for this project. See ultrasonic testing report TL-6027 Modified dated March 17, 2008 for more details.

Bay 1- QA Inspector identified specimens on the Production Monitoring Tests (PMT's) for Deck Panel DP351-001 and DP378-001 to be removed for macro testing.



Summary of Conversations:

No conversations took place between the QA and QC Inspector.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Quintana, Gabriel	Quality Assurance Inspector
Reviewed By:	Hager, Craig	QA Reviewer
